

Date: Thursday, 2/9/2006 1:35:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW INSTALLATION
Job Number : 25749A	
Estimate Number : 10098	
P.O. Number : N/A	Part Number : D30761
This Issue : 2/9/2006 S.O. No. : N/A	Drawing Number : D3076 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : <u>See COMMENT Below</u>	Due Date : 2/21/2006
Checked & Approved By : <u>06.02.10</u>	Qty: 40 Um: Each
Comment : Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.8949 sf(s)/Unit Total : 37.8980 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: M15411 11PC M100417 29PC

JF 06/03/27

20

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA186 and Dwg D3076

3-Identify as D3076-1

4-Deburr

JF 06/03/29

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JF 06/03/29

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4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JF 06/03/29

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:35:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 25749A

Part Number: D30761

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DB 06/03/31

Job Completion



u 06-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25749A
Description: R22 Bearpaw		Part Number: D3076-1
Inspection Dwg: D3076	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.07 x 45°				
B	0.63	+/-0.030	0.620"				
C	0.250	+/-0.010	0.252"				
D	0.950	+0.030/-0.010	0.946"				
E	5.50	+/-0.030	5.493"				
F	0.25 x 45°	+/-0.030	0.220 x 45°				
G	0.375	+/-0.010	0.376"				
H	0.475	+/-0.010	0.472"				
I	5.83	+/-0.030	5.838"				
J	3.80	+/-0.030	3.809"				
K	3.046	+/-0.010	3.042"				
L	3.638	+/-0.010	3.633"				
M	0.260	+0.005/-0.000	0.260"				
N	0.93	+/-0.030	0.929"				
O	0.30	+0.030/-0.000	0.312"				
P	7.000	+/-0.010	7.007"				
Q	10.14	+/-0.030	10.148"				

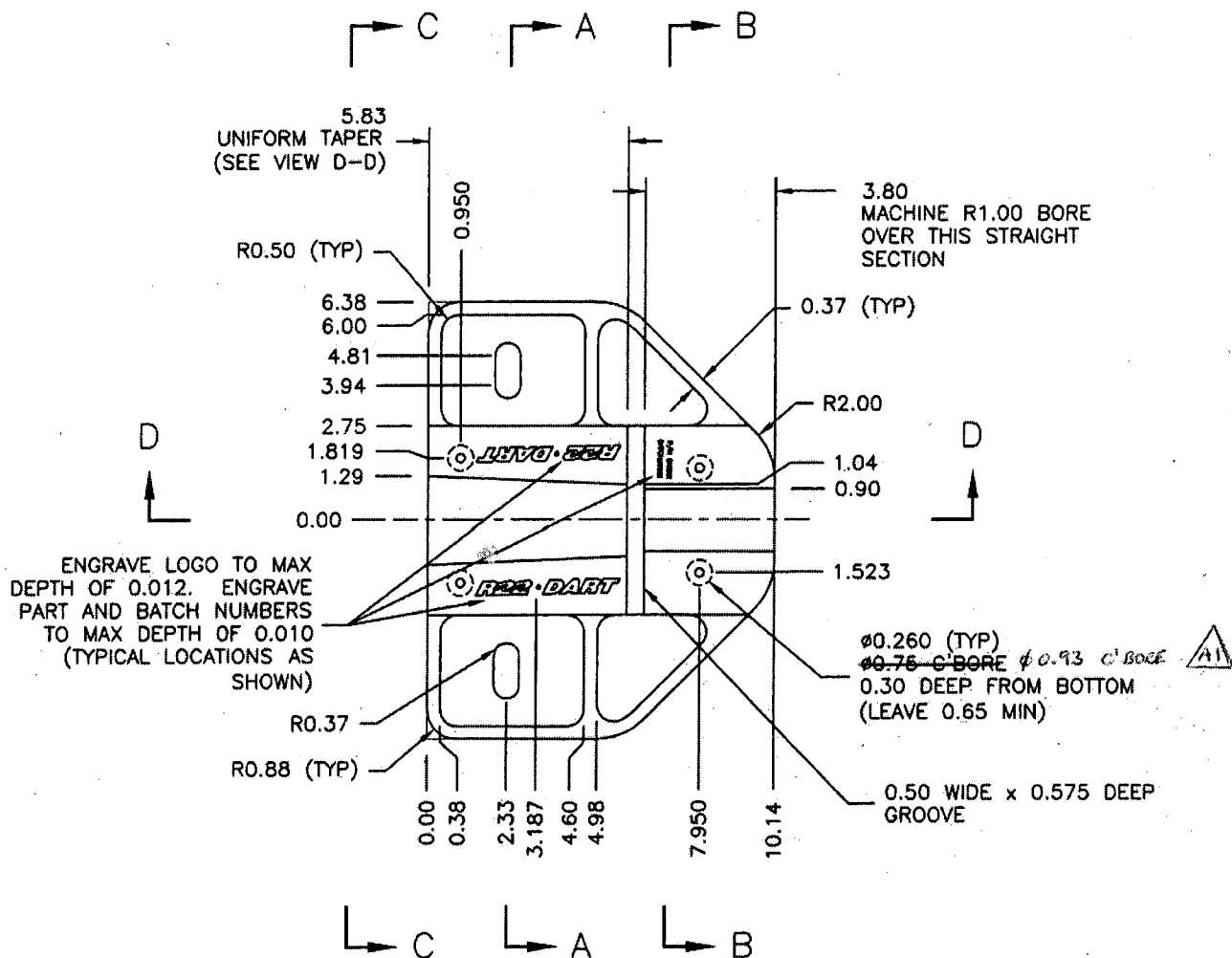
Measured by: J.F.	Audited by: SA	Prototype Approval: N/A
Date: 06/03/26	Date: 06.03.27	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	

DART

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 1 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:5
A	02.01.08	NEW ISSUE	
AI	RT 03.01.06	$\phi 0.93$ WAS $\phi 0.75$	

RELEASED
02.01.10 #



D3076-1 BEARPAW (FLAT PATTERN)

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

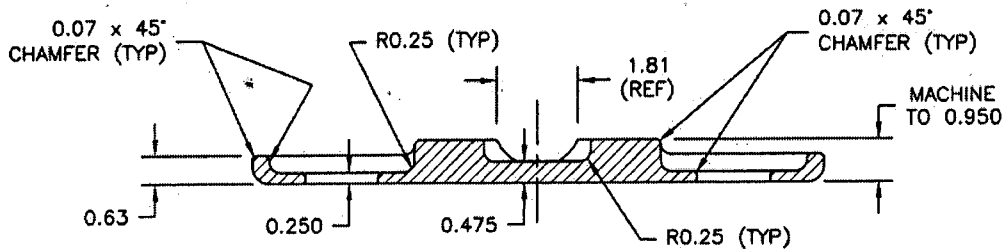
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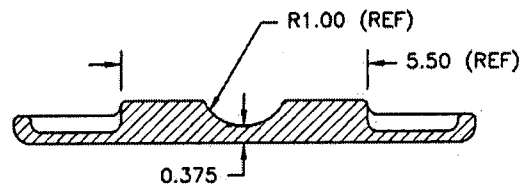
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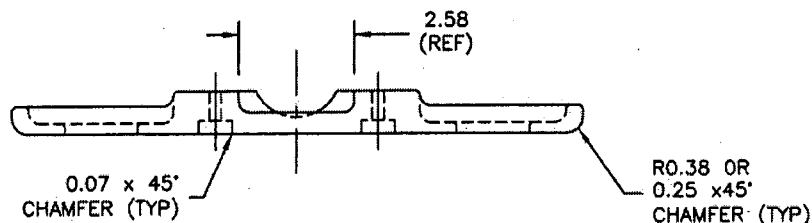
DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 2 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:4



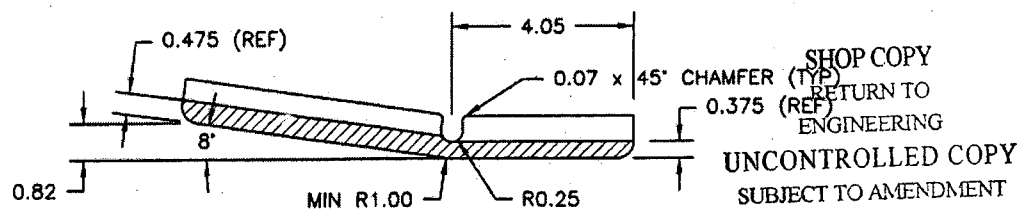
SECTION A-A

RELEASED
02.01.10 #

SECTION B-B



SECTION C-C



SECTION D-D (AFTER BENDING)

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